

Date: Monday, 04/05/2009 1:07:24 PM
 User: Chantal Lavoie

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: WEB		
Job Number	: 47707						
Estimate Number	: 10498						
P.O. Number	:			Part Number	: D2739		
This Issue	: 04/05/2009 S.O. No. :			Drawing Number	: D2739 REV D		
Prsht Rev.	: NC			Project Number	: N/A		
First Issue	: / / Type : SKIDTUBES			Drawing Revision	: D		
Previous Run	: 47681			Material	:		
Written By	:			Due Date	: 11/05/2009 Qty: 4 Um: Each		
Checked & Approved By	: <u>CL9/05/04</u>						
Comment	: Est Rev: C 02.11.28 Reformat KJ Est Rev: D 06-03-21 As Per Rev C JLM Est Rev: E 07-07-28 As per Rev D JLM Verified By:						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D26005108	Extrusion 'I Beam' thin	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Extrusion 'I Beam' thin Pick: Qty Part Number Description Batch 1 D2600-5 Web <u>B38589</u> ① Ma-5-4	
2.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1	
		Comment: LANDING GEAR RESOURCE 1 1-Cut D2600-5 to length as per Dwg D2739. 2-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739 3-Use uni-bit to open holes to finish size as per Dwg D2739. 4-Bevel Fwd end of extrusion and Deburr holes and ends. 5-Dburr	① Ma-5-4 ②
3.0	QC5	INSPECT WORK TO CURRENT STEP	
		Comment: INSPECT WORK TO CURRENT STEP	③ Ma-5-4 ④

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEB

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Part Number: D2739

Job Number:



Seq. #: Machine Or Operation:

Description :

4.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

(4)

19-5-4

5.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BE 9-5-4

(4)

6.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Use a red or black lead-free paint pen to write the part number and batch number in the middle of each web.

Identify and Stock
Location: LG.

(4) 19-5-4

7.0 QC21

FINAL INSPECTION/W/O RELEASE



09/05/05 (4)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-05-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

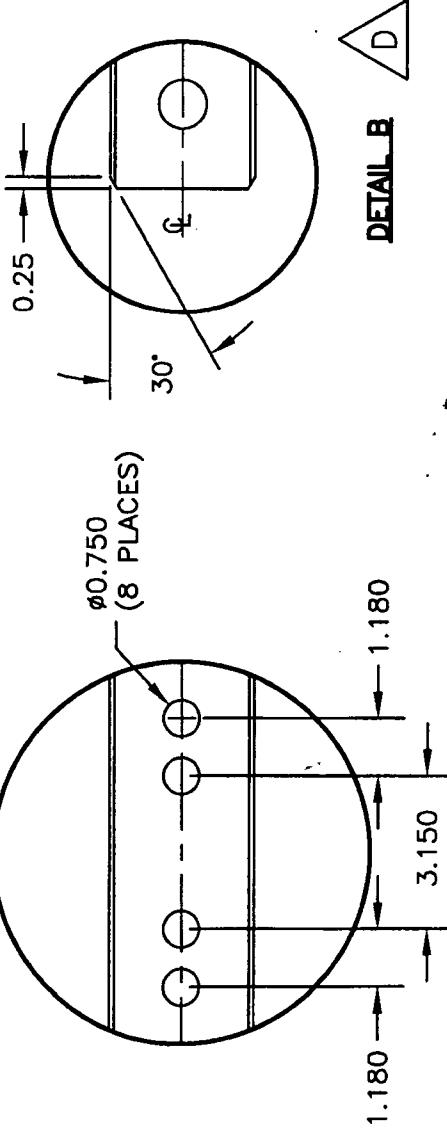
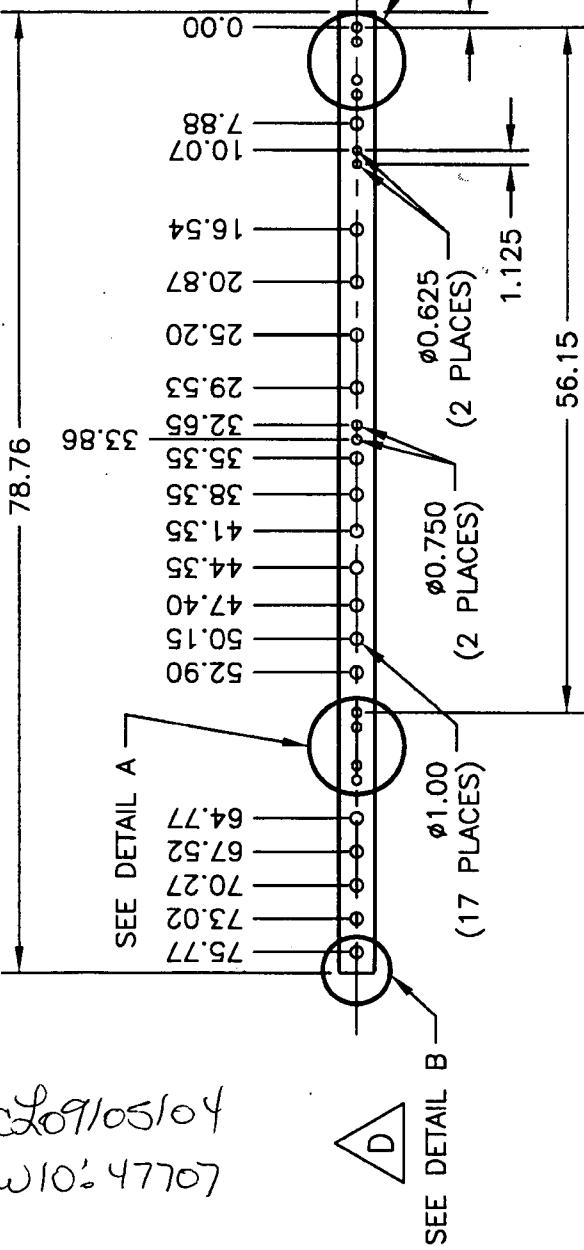
DART

DESIGN <i>PH</i>	DRAWN BY <i>CB</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D2739
DATE 07.05.29		REV. D SHEET 1 OF 1
		TITLE WEB
		SCALE 1:15

RELEASED

07.05.29

SEE DETAIL A



NOTES:

- 1) MATERIAL: MAKE FROM D2600-5 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) PART IS SYMMETRIC ABOUT ϕ

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